Page 1

.June-04-12 1:27:32 PM

Required Date: 18/06/2012

Item ID:

D350-636-013

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Skidtube LH Item Name:

> Start Oty: 1.00 04/06/2012

> > Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ Date: 12 06 64 Tooling:

SPC (Y/N):

Date: Date:

Tool # Plan

Code

Run

Reject

Qty

Accept

Qty

Number Stamp

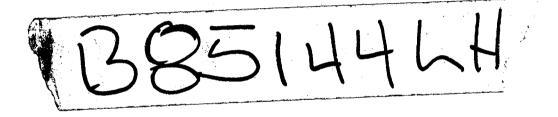
MUJ 12/07/11/

Insp.

Reject

Sequence ID/ Work Center ID	Opera Descri		Set Up/ Run Hours	Tool ID
Draw Nbr	Revision N	br		
D2750	F	:		
D3492	C			
IIN-D350-636	I	:		•
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100	DOCU	MENT CONTROL	4 6%	12/01/12
DC		Memo	0.00	11
Document Control		Photocopy blue file and type	a labels per PPP D350-636-013 CHG (006 JD

Date:



Dart Ae	rospace Lt	d								
W/O:			WO	RK ORDER CH	ANGES				· · · · · · · · · · · · · · · · · · ·	1
DATE	STEP	PRO	CEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Cated	iorv:	NC	R: Yes	No DQ	A:	Date:	
		lution:		•						
NCR:				R NON-CONFO				***		
		Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	otion	Sign Date	Sect	ion C = T	Chief Eng	QC Inspector
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June-04-12 1:2	7:32 PM					O:)	44								1 450	_
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube LH	13				Accept	*N9	NN	040	100)*	Setup	Start Stop	*N:	S1* S2*	
Start Date: Required Date Reference:	04/06/2012 : 18/06/2012	Start Qty: Req'd Qty			1* 1*		Cust Custo	Item I omer:	D:					IV.		
Approvals:	Process Pla	an:		Date:		Tooling:		Da	ate:			Run	Start	*N	R1*	
	QC:	·· ··		Date:		SPC (Y/N):		Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description Skidtubes				Set Up/ Run Hours 0.00	Тоо	l ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp	
Skidtubes Skidtubes			lemo - Pick D2600	0-3 Bent		0.00	_	_							e i eu l'alesse a	-
			- Deburr FWI FT end per d		s, remove b	ending marks. Scribe b	eatch# inside	BE	12/06/	25						
			- Drill pilot h eburr.	oles for blade fi	tting bolt h	oles using DT8983. Op	oen to 0.500",	`\	\ 	ملحا	WE)			•	\$"5
· •		4- fil	- Locate DT8 tting	330 off of blade	e fitting bol	t holes and drill pilot h	oles for blade		12/06/0	, -l·	700	3		Í	The second secon	
		5-	Drill only to	vo fwd step hole	es using DT	9616. Ensure proper p	ositioning.	00	12/06/2	5				.*		
		6- Ji	Drill pilot heg g DT8150 &	oles as per Dwg DT886 A for f	D2750 she irst side on	eet 4 (D2750-3 details) ly DT886 B for second	Drill using drill I side (detail B)									
		7- **	Clecko DT8	8863B on second SIDE***	d side of tu	be and drill pilot holes	for detail B.				B (2)	\œ	28	i 1		
¥		fit	tting location	holes to 0.500"	' (total of 4	to 0.375" (2 holes per holes per side) as per c il T to 0.500" (8 holes p	lwg D2750.			`	·		•			
		9- 0.:	Drill pilot ho 297".	oles for wearplat	tes as per D	wg D2750 using DT81	08 open to	/	/							

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

Dart Ae	rospace	Ltd								· American
W/O:			W	ORK ORDER CI	HANGES				-	1 6 1
DATE	STEP	PI	ROCEDURE CH	EDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	tegory:	NC	R: Yes I	Vo DQ	A :	_ Date: _	
	Resolution:			ion:	QA	: N/C Cld	sed:		Date: _	
NCR:			WORK ORI	DER NON-CONF	ORMANCE	E (NCR)			
		Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descr Chief Eng	iption	Sign & Date		ion C	Chief Eng	QC Inspector
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0.00

QC5- Inspect part completeness to step on W/O

Memo

130

130

Quality Control

Dart Ae	rospace	Ltd								٨
W/O:			W	ORK ORDER CH	ANGES					, 1 6
DATE	STEP	PRO	CEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	Corrective Action Sec			Sign &		cation	Approval	Approval
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June-04-12 1:27:32 PM

Quality Control

Item ID: D350-636-013 Accept *N900040100* Setup Start **Revision ID:** Skidtube LH Item Name: Start Qty: 1.00 **Start Date:** 04/06/2012 Cust Item ID: **Required Date:** 18/06/2012 **Req'd Qty:** 1.00 Customer: Reference: Start Run **Approvals:** Process Plan: Date: Tooling: Date: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Qty Number Stamp **Run Hours** Code Otv 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* HandFinish 0.00 Memo Hand Finishing 150 QC7-Inspect Chemical Conversion Coat 0.00 *150* QC 0.00 Memo

Dart Aeı	rospace	e Ltd					•	•		
W/O:			WC	RK ORDER CH	ANGES		To a			• • •
DATE	STEP	PRO	CEDURE CHAI	NGE		Ву	Dáte	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NC	R: Yes	No DQ	A:	Date: _	
Resolution:			Disposition	n:	QA	: N/C CI	osed:		Date: _	
NCR:		1	WORK ORDI	R NON-CONFO	RMANCI	E (NCF	1)			
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DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign 8 Date		tion C	Chief Eng	QC Inspector
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June-04-12 1:27:32 PM D350-636-013 Item ID: Accept *N900040100* Setup Start **Revision ID:** Skidtube LH **Item Name: Start Date:** 04/06/2012 Start Qty: 1.00 Cust Item ID: **Required Date:** 18/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Date: Approvals: Tooling: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Set Up/ Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty **Qty** Number Stamp 160 0.00 Skidtubes *160* Skidtubes 0.00 Memo Skidtubes 1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750 3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750. 4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10) 5-Deburr and blow out all chips from inside of tube. Prepare tube for welding. remove alodine as required. 6-Bond web D2739 in place as per QSI 015 DC 12/07/03 A/R Sikaflex-291 batch: 12/409 7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 10) A/R Aluminum Rod batch: M122110 8-Grind welds flush as per Dwg D2750 9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750 SE 12/07/06 10-Deburr holes

Dart Aerospace Lt	d
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W/O:			W	ORK ORDER CHANG	IGES ·								
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	D	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No		PAR #:	Fault Ca	tegory:	NCR: Yes No DQA: Date:								
	R	esolution:	_ Disposit	ion:	QA: N/C	Close	ed:	Date: _	<u></u>				
NCR:		W	ORK OR	DER NON-CONFORM	IANCE (N	CR)							
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	ction B	ın &	Verification	Approval	Approval				
		Section A	Chief Eng	Chief Eng		ate	Section C	Chief Eng	QC Inspector				
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Work Order ID 85144

85144

Page 6

June-04-12 1:27:32 PM

Required Date: 18/06/2012

Item ID: D35

D350-636-013

Accept

N900040100

Setup Start

*NS1

Revision ID:

Start Date:

Item Name:

Skidtube LH 04/06/2012

Start Qty: 1.00 Reg'd Oty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

QC: _____ Date: SPC (Y/N):

QC10- Inspect visual per OSI004- ground welds

QC5- Inspect part completeness to step on W/O

Tooling:

Date:

Run Start *

Stop

KNIDO:

Sequence ID/ Work Center ID Operation Description

Set Up/ Run Hours Tool ID Tool # Plan

Accept Qty

Code

Reject Ro

Reject Insp. Number Stamp

·170

*17**0***

Memo

0.00 612/09/09

Quality Control

180

180

QC

Memo

0.00

812/4/0

Quality Control

190

Pressure Wash per OSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 No 12-79

Dart Aerospace Ltd

W/O:			W	ANGES								
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:		Date: _	<u> </u>			
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DATE	STEP	Description of NC			etion B	Verifica	tion	Approval	Approval			
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0.00

1-Install inserts as per dwg D2750

HandFinish

Hand Finishing

Dart Aerospace I	Ltd
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W/O:			V	S								
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No						ICR: Yes No DQA: Date:						
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Item ID: Revision ID: Item Name:	D350-636-0	13		Accept	*N900	040	100)* s	Setup	Start Stop	1 🕠	S1* S2*
Start Date: Required Date: Reference:	04/06/2012 18/06/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					ı VI	
Approvals:		n:	Date:	Tooling:		ate:		F		Start Stop	7	R1* R2*
Sequence ID/ Work Center II 230 *230* HandFinish Hand Finishing		2-Spray in 3-Install by per dwg D SIKA FLE BATCH: EXP DAT 4-assemble A/R 55-o'		D3492 and apply o'ring lu	be	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
240 * 740 * QC Quality Control		QC5- Inspect part com	pleteness to step on W/O	0.00	07							and the second second second

Dart	Aeros	pace	Ltd
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W/O:			V	VORK ORDER CHANG	ES				
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Part No	•	PAR #:	_ Fault Ca	tegory:	_ NCR: Y	es N	o DQA:	Date: _	
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DATE	STEP	Description of NC	1-22-1		Section B iption Sign &		Verification	Approval	Approval
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85144

Page 9

June-04-12 1:27:32 PM

Item ID:

D350-636-013

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Skidtube LH

Required Date: 18/06/2012

04/06/2012

Start Qty: 1.00 Reg'd Qty: 1.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Stop

Sequence ID/ **Work Center ID**

Operation Description

Pick Kit

Set Up/ **Run Hours**

Tool # Plan Code Accept

Reject

Reject Insp.

250 *250*

Packaging Packaging

Memo

Memo

0.00

0.00

Date:

Qty

Qty

Number Stamp

260

QC4-100% Inspect kits for completeness

0.00

0.00

Quality Control

270

970 Packaging

Packaging

Memo

Packaging

Package as per PPP D350-636-013

KAMBO)

Dart	Aeros	pace	Ltd
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W/O:	:	WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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DATE	STEP	Description of NC			tion B	Verif	ication	Approval	Approval		
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Work	Orda	μ ID	85144
work	Orae	r ID	85144

85144

Tool ID

Tool # Plan

Code

Page 10

June-04-12 1:27:32 PM

Item ID: D350-636-013 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Skidtube LH **Start Date:** 04/06/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 18/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Start Run Tooling: **Approvals:** Process Plan: Date: Date: Stop QC: Date:____ SPC (Y/N): Date:

280 *280*

Sequence ID/

Work Center ID

QC Quality Control

Memo

Operation

Description

QC21- Final Inspection - Work Order Release

0.00

0.00

Set Up/

Run Hours

Reject

Reject

Qty

Accept

Qty

MUJ 12107/13 MUJ 12107/13

Number Stamp

Insp.

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHAN	GES				
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NCR:			WORK ORDE	R NON-CONFORM	MANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Action Description	ection B Sign	& Secti	cation ion C	Approval Chief Eng	Approval QC inspector
			Chief Eng	Chief Eng	Date	3			
									

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June-04-12 1:27:36 PM

* Work Order ID: 85144.

D350-636-013

Parent Item Name: Skidtube LH

85144

D350-636-013

EC

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

IPP Rev:H02.09.25Rearranged procedure steps KJ

IPP rev I

06.03.30 Per rev. D dwg

IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec 10.06.22 revise seg110 DD verf:EC

IPP Rev:L IPP Rev:M 10.10.01 as

ner IIN revH_DD_verf:FC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	29.0000	1	1			
D2600-3-	RFNT								**		DE	12/06/	25
				Location		Loc	<u>Qty</u>	Loc Code					
				LG			29				_		
					66875		7				_		
					73253		i				_		
					75021		1				_		
					75022		1				_		
					75023		1				_		
					81330		4				_		
					83305		1		_		_		
					83442		13				_		
D3493-1		Manufactured	No			110	Each	127.0000	2	2 V	-		
*D3493-13	*								**	82	13	12,	107/

Location Loc Qty Loc Code ST050 127 77573 1 82023 26 83097 100

Page 1

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector

Part No: _		PAR #:	Fault Category:	NCR: Yes No DQA: _	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:
NCR:		WC	ORK ORDER NON-CO	NFORMANCE (NCR)	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	,	Verification	Ammercal	Annuoval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
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Picklist Print June-04-12 1:27:36 PM									Page 2
• Work Order ID: 85144 Parent Item: D350-636-013 Parent Item Name: Skidtube LH			5144* 350-636-0	13*			tart Date: 0 Start Qty: 1.		Required Date: 18/06/2012 Required Qty: 1.00
D2739 *D2739* 350 Beam	Manufactured	No		160	Each	13.0000	l * *	1 DC 12	/07/03
			Location LG 72155 81508 83447 83448 83548	86	13 1 1 4 5	Loc Code		Ø	- - - - -
*D2744 *D2744* Cap	Manufactured	No	<u>Location</u>	160	Each Loc Qty	35.9000 Loc Code	1 **		BC 12/06/25
			LG002 62715 78900 83412		35 1 3 31				- - -
*D3490-1 *D3490-1* Cross Bolt Spacer	Manufactured	No		160	Each	45.0000	4 **	4	BB5419 - VI
			Location		Loc Qty	Loc Code			WW11/ x7

LG 81976 LG001 62450 74875 77042 83269 34

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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				<i>;</i>			-		
Part No:	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA:	Date:		
	R	esolution:	_ Disposit	ion:	QA: N/C Clo	sed:	Date: _		
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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Picklist Print

June-04-12 1:27:36 PM

Work Order ID: 85144

Parent Item:

D350-636-013

Parent Item Name: Skidtube LH

85144 *D350-636-013*

Start Date: 04/06/2012

Required Date: 18/06/2012

Required Qty: 1.00

D3490-5

-Cross Bolt Spacer

Manufactured

No

160

Each

57.0000

Start Qty: 1.00

**

Page 3

Location Loc Qty Loc Code LG 13 13 78958 LG001 44 44 83373 220 Each 296.0000 Manufactured No

**

BE 12/07/05

Location Loc Qty Loc Code LG 222 81965 55 83262 167 LG001 74 67766 4 3 68251 73403 64 74445 79517 2

D2743

D2743 Crossbolt Spacer

June-04-12 1:27:36 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr Approval QC Inspector Approval QC Inspector Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:

QA: N/C Closed:

Date:

Disposition:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section B		Verification		A						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector						
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NOTE: Date & initial all entries

Resolution:

Picklist Print June-04-12 1:27:36 PM								- ·- · · · · · · · ·	Page 5
Work Order ID: 85144 Parent Item: D350-636-013 Parent Item Name: Skidtube LH			5144*)350-636-0	113*					
. Skidde Eff							art Date: 0 start Qty: 1		Required Date: 18/06/2012 Required Qty: 1.00
AN3C6A BOLT	Purchased	No		230	Each	451.0000	4 **	4 <u>H</u>	12/07/10
			<u>Location</u> FP001	<u>L</u> .	oc Oty	Loc Code			
			111982		1				- -
			ST351		450				-
			111982 116419		2 23				-
			116549		2				_
			116704		12				_
			117619		10				_
			117688		1				-
			117872		5				-
			118422		13				-
			119449 120423		21 3				-
			120693		158				-
			121682		200			XU	-
AN6C44A	Purchased	No	,	230	Each	86.0000	4	4	-
AN6C44A ?\							**	M	12/02/10
Doll			<u>Location</u>	Le	oc Qty	Loc Code			
			FG		2				

Dart Aerospace Ltd

N/O:		WORK ORDER CHANGES Approval											
DATE	STEP	PRO	CEDURE CH	CEDURE CHANGE By Date Qty						Approval QC Inspector			
			-						Prod Mgr				
								ļ.					
Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQA:		Date:				
	Resolution:								_ Date: _				
NCR:			VORK OR	DER NON-CONFORM	IANCE	(NCR)							
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B	Sign & Date	Verificat Section		Approval Chief Eng	Approval QC Inspector			
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Work Order ID: 85	144		*85144								
Parent Item: Di	350-636-013 Skidtube LH		*D350		13*		ç.	tart Date: 0	M/06/2012	Dequired Date: 19/0	. <i>(-)</i> 2012
Tarone Item Panie.	onidesee Bri							Start Qty: 1		Required Date: 18/0 Required Qty: 1.00	
AN8C35A		Purchased	No		230	Each	68.0000	1	1		
AN8C35	5A							**	M	(207/10	·
			<u>Locatio</u>	<u>n</u>	<u>Lo</u>	c Qty	Loc Code				
			FP002			67				_	
				115960		1				_	
				118286		16				-	
				121275		50			X /	-	
			ST346			1				-	
				114442		0				-	
				115188		0				_	
AN960C10L	NAS1149C0332	Purchased	No	115960	230	i Each	0.0000	38	38	-	
*AN960C						1/1 172	1063	**	(y3g)	M Worl	10

D2	74	5
Bushing		

washer

D2745

Manufactured

230

Each

1/1122063

122.0000

(v38) M 12/02/10 8 M 12/07/10

Loc Qty Loc Code Location 1385416 FP 79518 FP001 116 69529 76142 83260 114

Page 6

W/O:			WORK ORDER CHANGES											
DATE	STEP	PROC	EDURE CH	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
	:													
Part No		PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _							
Resolution:			_ Disposit	ion:	QA: N/C CI	osed:	Date: _							
NCR:			ORK OR	DER NON-CONFORM	ANCE (NCR	R)								
DATE	STEP	Description of NC	la iai al		tion B	Verification		Approval						
	,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector						
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Work Order ID: 85144 Parent Item: D350-636-013 Parent Item Name: Skidtube LH			5144* 350-636-0	13*			Start Da Start Q		4/06/2012 00	Required Date: 18/06/2012 Required Qty: 1.00
D3488-041 *\(\bar{D}\)3488-041* Blade Fitting Assembly, LH	Manufactured	No		230	Each .	9.0000	**	1	1 H	12/07/10
			Location FP002 61689 82271	<u>Lo</u>	9 1 8	<u>Loc Code</u> ころら				- -
D3492-1 *D3492-1* Plug	Manufactured	No		230	Each	257.0000) **	8	8 M	(2/02/10
			Location FP002 69531 74444 76235 83259 FP-A	<u>L</u>	242 8 2 4 228 15	Loc Code	1			- - - -
D3492-5 *D3492-5* Plug	Manufactured	No	05070	230	Each	161.000	0 **	8	8	l 11/07/10
			Location	La	oc Qty	Loc Code	1			

161

60

101

fpa

83100

83530

Dart Aerospace Ltd

W/O:			•	* .					
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	_ Date: _	
 -	R	esolution:	Disposit	ion:	_ QA: N/C C	losed:		Date: _	
NCR:			VORK OR	DER NON-CONFORM	ANCE (NCI	R)			
DATE	CTED	Description of NC			tion B	Verific	cation	Approval	Approval
DAIL	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign o	Secti	ion C	Chief Eng	QC Inspector
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June-04-12 1:27:36 PM					-					
Work Order ID: 85144		*8!	5144*							
Parent Item: D350-636-013 Parent Item Name: Skidtube LH		*D	350-6	36-0	13*		Ç,	tart Date: (04/05/2012	Required Date: 18/06/2012
								Start Qty: 1		Required Qty: 1.00
D3535-25	Manufactured	No			230	Each	34.0000	1	1	
D3535-25								**	Xl	ulozlu
			Location		<u>Lo</u>	c Qty	Loc Code			
			FP001			34				<u></u>
				233		1				_
				357 2156		2				_
				387		17				
				899		13			У.(-
D3536-25	Manufactured	No			230	Each	28.0000	1	1	
D3536-25								**	11	12/07/10
			Location		<u>Lo</u>	c Qty	Loc Code			
			FP			28	13			_
				391		12			X (-
D2527.1			83	900		16				_
D3537-1	Manufactured	No			230	Each	83.0000	3	3	,
D3537-1 Wearpad								**	M	12/07/10
			Location		<u>Lo</u>	<u>e Qty</u>	Loc Code	,		
			FG			10				_
				833		10				_
			FP002			73				=
				817		5				~
			81	360		14				

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Dart Aerospace	e Ltd
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DATE	STEP	PROC	EDURE CH	IANGE	ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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		,					· · · · · · · · · · · · · · · · · · ·						
Part No	•	PAR #:	_ Fault Ca	tegory:	NCR:	Yes N	o DQ	\:	Date:				
			Disposition: QA: N/C Closed: Date:										
NCR:			ORK ORI	DER NON-CONFORMA	MCE (NCR)							
DATE	STEP	Description of NC	Corrective Action Section E				Verific	ation	Approval	Approval			
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Date	Section	on C	Chief Eng	QC Inspector			
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Work Order ID: 85144

Parent Item:

D350-636-013

Parent Item Name:

Skidtube LH

85144 *D350-636-013*

81874

83588

68062

75548

54363

Location

FG

ST072

Location

Location

FP002

ST060

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-1

D3631-1

Washer

Manufactured

230 Each

Loc Qty

332

330

15

2

13

Each

2

347.0000

Loc Code

774.0000

Loc Code

**

W107/10

D3672-13 Phenolic Washer

D3791-1

Wearplate

D3793-1

D3793-1 Wearshoe

Purchased

No

No

Manufactured No

230

774 Each

774

Loc Qty

Loc Qty

17.0000

Loc Code

**

**

Manufactured No 62239 83392

230

230

2 15 Each

17

28.0000

**

Location Loc Qty Loc Code FP001 28 82171 2 83393 13 83903 13

Dart Aerospace Ltd

N/O:		WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE			Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	ļ								
		7							
Part No:		PAR #:	Fault Category:		NCR: Yes No DQA:		Date: _	 	
	Resolution:		Disposition:		QA: N/C Clo	sed:	Date: _	Date:	
NCR:		We	ORK OR	DER NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC	Corrective Action Section			Verification		Approval	
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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• Work Order ID: 85144

Parent Item:

D350-636-013

Parent Item Name: Skidtube LH

85144 *D350-636-013*

83394

83901

82167

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

D3793-3 *

Wearshoe

Manufactured

230

Loc Qty

Each

28.0000

Il 12/07/10

D3794-1

D3794-1

Gasket

Manufactured

No

Location

Location

FP

FP002

FP001

230

12 Each

6

20

16

26.0000

Loc Code

Loc Code

1382166

**

121071

D3794-3

Gasket

Manufactured

83395 230

20 Each

Loc Qty

23.0000 **

Location Loc Qty Loc Code FP 21 83396 21 FP002 2 74530

W/O:			V	VORK ORDER CHANGI	ES		-	* .					
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
							: : : :						
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA :	Date: _						
Resc		esolution:						Date:					
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCF	R)							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign 8	Verification Section C	Approval Chief Eng						
			Chief Eng	Chief Eng	Date								
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June-04-12 1:27:36 PM									Page 11
Work Order ID: 85144	· · · · · · · · · · · · · · · · · · ·	*8	5144*	-					······································
Parent Item: D350-636-013			350-636-0	112*					
Parent Item Name: Skidtube LH		• .).).)()—().)()—(11.)		S	tart Date: 0	4/06/2012	Required Date: 18/06/2012
							Start Qty: 1		Required Qty: 1.00
MS21043-6	D1	No		230	Faals				required Qey 1.00
	Purchased	NO		230	Each	618.0000		4	1 1
MS21043-6							**	Jul	n(07)11
			Location	Lo	c Qty	Loc Code			
			FG		20				_
			103693		20				_
			ST301		598				_
			117887		2				_
			118384		96			X \	_
M621002C0		2.1	120308	•••	500		_	-	-
MS21083C8	Purchased	No		230	Each	81.0000	1	1	
MS21083C8							**	HL	1107/10
			Location	Lo	c Qty	Loc Code			
			304		75				_
			121185		29				_
			121349		46			<u> </u>	_
			FP002		1				_
			115884		l				_
			ST303		4				_
			115884		0				_
			118077		1				-
			119309 119638		2				-
					1			-	-
			ST304 121524		1				-
NAS1149C0832R	Purchased	No	121324	230	Each	257.0000	1	1	-
*NAS1149C083				250	Such	237.0000	**	'M	17/07/10
			Location	Lo	c Oty	Loc Code			
			ST297		257				
			1 <u>14915</u>		257				-
June-04-12 1:27:36 PM			Shop	Packet Print					Page 11

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W/O:		<u></u>	W	ORK ORDER CHANG	ES			· 			
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Part No	, <u>.</u>	PAR #:	Fault Cat	tegory:	NCR: Yes No DQA: Date:						
	Res	solution:	Disposit	ion:	_ QA: N/C	Clos	ed:	Date: _			
NCR:			WORK OR	DER NON-CONFORM	ANCE (N	CR)					
DATE	STEP	Description of NC		tion B	0	Verification	Approval	Approval			
	OI-LI	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector		
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Work Order ID: 85144		*8	5144*						
Parent Item: D350-636-013 Parent Item Name: Skidtube LH		*\	350-636-	013*		Sta	rt Date: 04	4/06/2012	Required Date: 18/06/2012
							art Qty: 1.		Required Qty: 1.00
NAS1515H3L	Purchased	No		230	Each	146.0000	4	4	
*NAS1515H3I *							**	M	nloghd
			Location	Lo	oc Qty	Loc Code			
			FG		40				_
			102472		40				_
			ST277		106				_
			118686		3				_
			119438		1				_
			120360		11				_
			121243 12155 <u>6</u>		2 89				_
NAS1611-005	Purchased	No	121330	230	Each	180.0000	8		-
	Fulchaseu	140		230	Lacii				1
NAS1611-005						·	**	M	12/07/10
			Location	<u>L</u> c	oc Qty	Loc Code			
			FP001		180				_
			106099		18				
			114220		78			X &	_
			119438		44				_
			121415		40				

W/O:			W	ORK ORDER CHANG	ES			5 4
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Qty Chief Eng / Prod Mgr QC Inspector Date: Date: Approval Approval Approval Approval Approval Approval	
Part No	• •	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:	Date: _	
		esolution:						
NCR:		1	WORK ORI	DER NON-CONFORMA	NCE (NCF	?)	1	
DATE	STEP	Description of NC	1-121-1	Corrective Action Section	on B	Verification		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
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• Work Order ID: 85144		*8	5144*							
Parent Item: D350-636-013			350-636-0	13*						
Parent Item Name: Skidtube LH							art Date: 0 tart Qty: 1		Required I Required	Oate: 18/06/2012 Qty: 1.00
NAS1611-010	Purchased	No		230	Each	188.0000	8	8		
NAS1611-010							**	ll	ulo	410
			Location	<u>L</u>	oc Qty	Loc Code				
			FP001		188					
			110915 117460		14				-	
			118077		8				-	
			118612		3				-	
			119438		47				-	
			121259		2			-	-	
			121415 121584		4 59				-	
			121723		59 50			X Q	-	
_AN8C21A	Purchased	No		250	Each	57.0000	2	2 ~	•	
AN8C21A	, u. o. u. o.						**		28	50
			Location	L	oc Qty	Loc Code				
			ST343	_	57					
			118758		3				-	
			121167		4				·	
•			121275		50			121275	<u> </u>	
D274i	Manufactured	No		250	Each	20.0000	1	1 /		
D2741 Blade, 350 Skidtube							**	83135	73	12/67/
			Location	<u>L</u>	oc Qty	Loc Code				
			ST		-10				-	
			ST466		30				-	
			71856		1				-	
			79516		19				-	
June-04-12 1:27:36 PM			Chan I	Packet Print						Page 13

N/O:			W	ORK ORDER CHANG	GES					, , ,
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Category: NO			NCR: Yes No DQA: Date:				
	Res	olution:	Disposition	on:	QA:	N/C Clo	sed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	f lat - t		ction B	Cian 9	Verific		Approval	Approval
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Work Order ID: 85144	- 	*2	5144	*							
Parent Item: D350-636-013 Parent Item Name: Skidtube LH				.636-()13*			art Date: tart Qty:	04/06/2012 1.00	_	1 Date: 18/06/2012 d Qty: 1.00
MS21083C8	Purchased	No			250	Each	81.0000	2	2	V	
MS21083C8								**		JB	286
			Location	1	<u>Lo</u>	<u>Oty</u>	Loc Code				
			304			75					
				121185		29					
				121349		46			1213	19.	
			FP002			1			-		
				115884		1					
			ST303			4					
				115884		0					
				118077 119309		1					
				119638		1					
			ST304	. 1,7000		1					
			3.50.	121524		1				_	
NAS1149D0863J	Purchased	No			250	Each	251.0000	2	2		
*NAS1149D086								**		-JB	12/07/1
			Location	<u>1</u>	Lo	<u> Qty</u>	Loc Code				

W/O:			V	VORK ORDER CHANGE	ES			·	•
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA	\ :	Date: _	
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NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
Part No:	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Date			Approval Chief Eng	Approval QC Inspector
7. (A. 14									
			1						

•	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
	X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
		Х			D2750-042	350 SKIDTUBE ASSEMBLY, RH
			Х		D2750-043	350 SKIDTUBE ASSEMBLY, LH
				X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
					-	
	1	1	1	1	D2739	WEB
	8	8	8	8	D2743	SPACER
	1	1	1	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
	1				D2750-1	SKIDTUBE WELDMENT, LH
		1			D2750-2	SKIDTUBE WELDMENT, RH
			1		D2750-3	SKIDTUBE WELDMENT, LH
				1	D2750-4	SKIDTUBE WELDMENT, RH
	1		1		D3488-041	BLADE FITTING, LH
		1		1	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
	4	4			D3490-3	SPACER
			4	4	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
	œ	8			D3492-043	PLUG ASSEMBLY
			8	8	D3492-045	PLUG ASSEMBLY
	1	1	1	1	D3535-25	WEARSHOE
ا م	1	1	1	1	D3536-25	GASKET
/F\ [3	3	3	3	D3537-1	WEARPAD
	8	8	8	8	D3631-1	WASHER
	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	D3793-1	WEARSHOE
\triangle	1	1	1	1	D3793-3	WEARSHOE
Æ ; [1	1	1	1	D3794-1	GASKET
LI	1	1	1	1	D3794-3	GASKET
						<u> </u>
Æ	38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
L	34	34	34	34	AN3C5A	BOLT
[4	4	4	4	AN3C6A	BOLT
[4	4	-4	4	AN6C44A	BOLT
	1	1	1	1	AN8C35A	BOLT
△ 38	38	38	38	AN960C10L	WASHER	
Æ	1	1	1	1	AN960C816L	WASHER
<u>- </u>	4	4	4	4	MS21043-6	NUT
[1	1	1	1	MS21083C8	NUT
Ī	4	4	4	4	NAS1515H3L	WASHER

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER MLJ NO. 851 17 06 04

F	INCORPORATE DSI 9413: OTY (3) 05357-1 WAS OTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-137-35 (ZN C8-1); D3794-1/-3 REPLACES D3535-137-35 (ZN B8-1); D3794-1/-3 REPLACES D3536-137-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SAODLE REMOVED (8 PL), WEARSHOE HARDWARE OTY UPDATED (ZN B8-1); D348B-0417-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	РН	08.07.16
Ę	CHANGE TO STAINLESS STEEL WEARPLATES. ADD RUBBER GASKETS: CHANGE INSERTS: ADD D3631-1; REMOVE QT (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, OTY (2) AN960C816; REMOVE QTY (2) MS21083C9	СВ	07.05.17
D	ADD HOLES AND SHACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	РН	06.01.05
С	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
В	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
Α	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE

****		DEGOTAL HOLE	1 01	DAIL		
DESIGN	PU,	DART AEROSPAC	EUSA	INC.		
DRAWN	RH	PORT HADLOC		,		
CHECKED		DRAWING NO.		REV. F		
MFG. APPR.	ALC:	D2750	:	SHEET 1 OF 11		
APPROVED	IM	TITLE		SCALE		
DE APPR.		🖺 350 SKIDTUBE ASS	EMBLY	/ NTS		
O.80 DATE	7.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THE OCCUMENT IS FRIMATE AND COMPRESTION AND IS SUPPLIED ON THE EXPRESE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COMPRES OF COMPRESTION TO WHAT IT IS THE WAY THE TO BE USED.				

GENERAL NOTES:

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MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0). FINISH:

FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: N/A

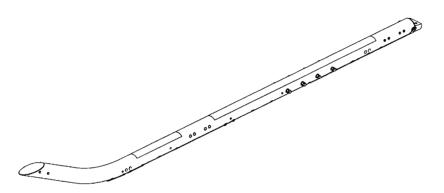
BREAK SHARP EDGES: N/A
IDENTIFICATION: N/A
WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
WELD PER DART QSI 004
INSTALL ALSA-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YILD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
PAGE
SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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	01-11-1	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
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D2750-041 350 SKIDTUBE ASSEMBLY, LH D2750-042 350 SKIDTUBE ASSEMBLY, RH DART AEROSPACE USA, INC. PORT HADLOCK, WA DESIGN DRAWN CHECKED DRAWING NO. REV. F D2750 MFG. APPR. SHEET 2 OF 11 APPROVED TITLE 350 SKIDTUBE ASSEMBLY DE APPR. DATE 08.07.16

W/O:			WORK ORDER CHANGES									
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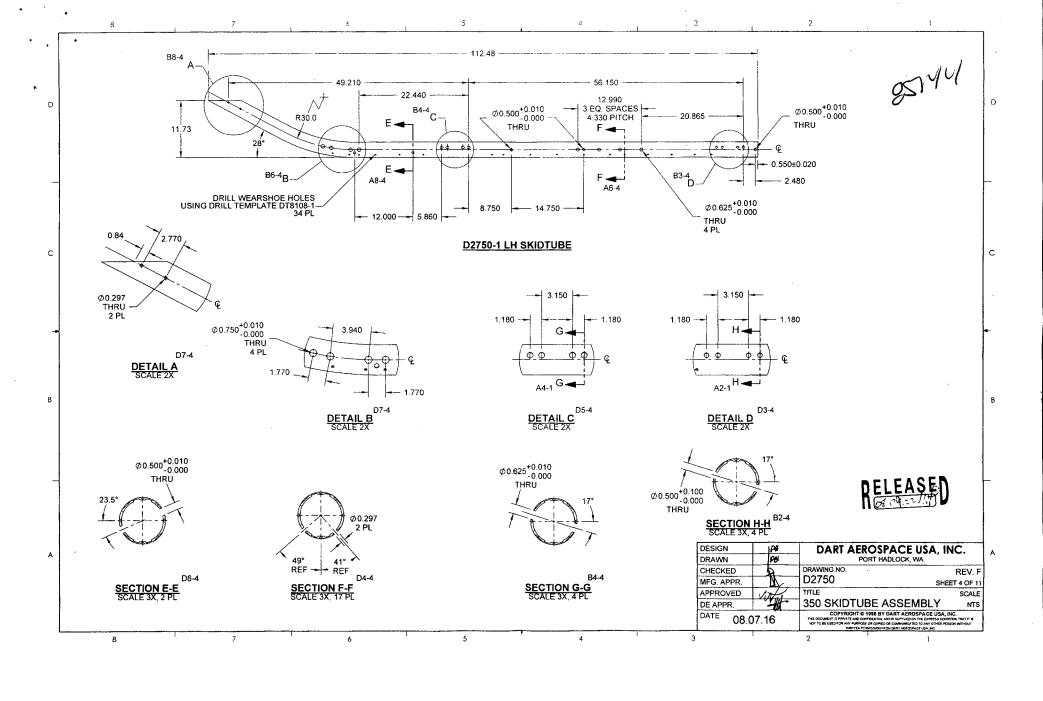


D2750-043 350 SKIDTUBE ASSEMBLY, LH

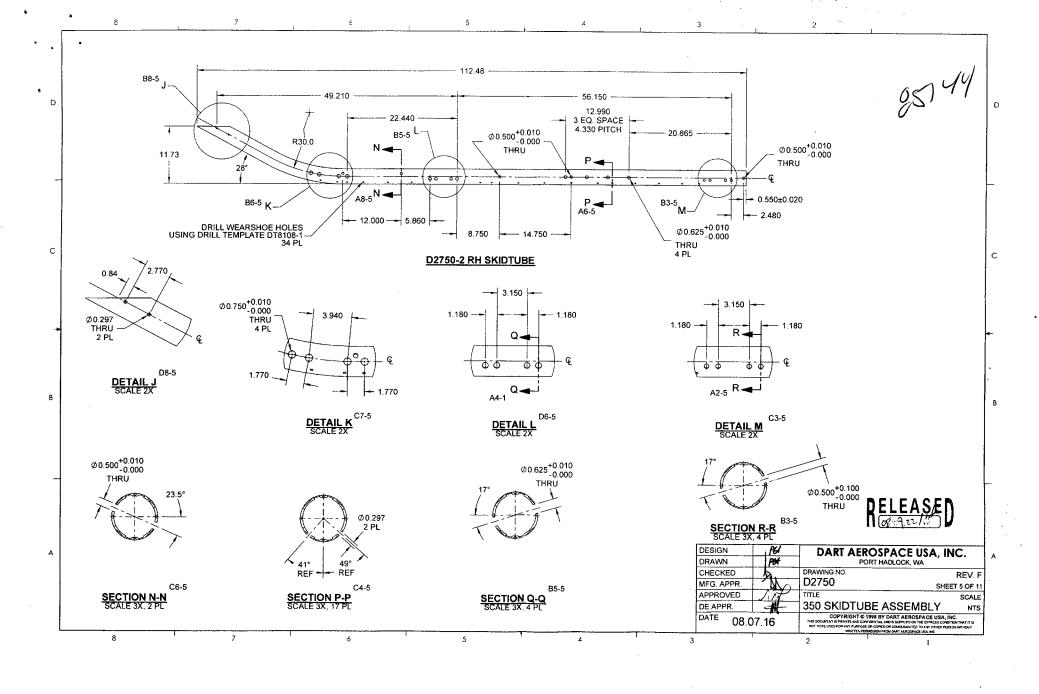
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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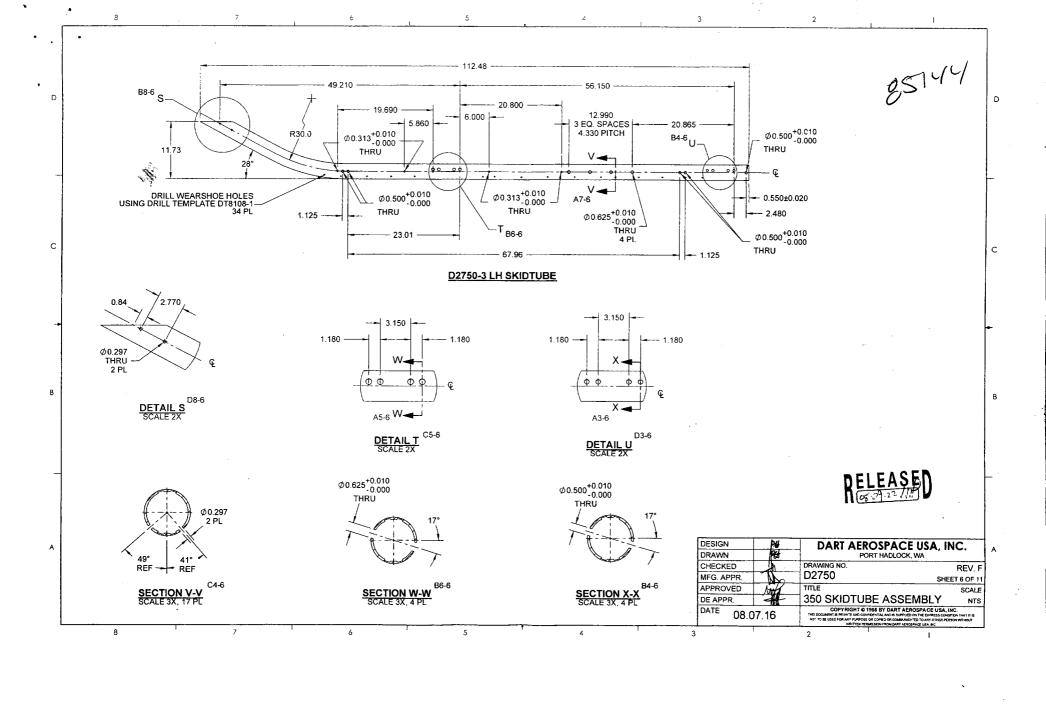
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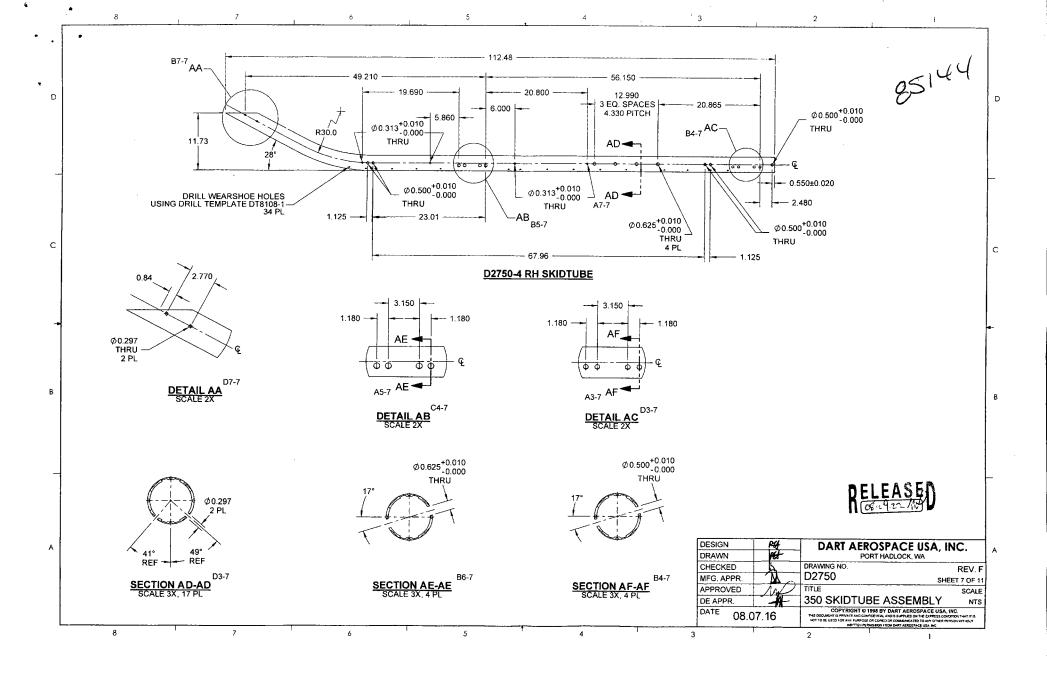
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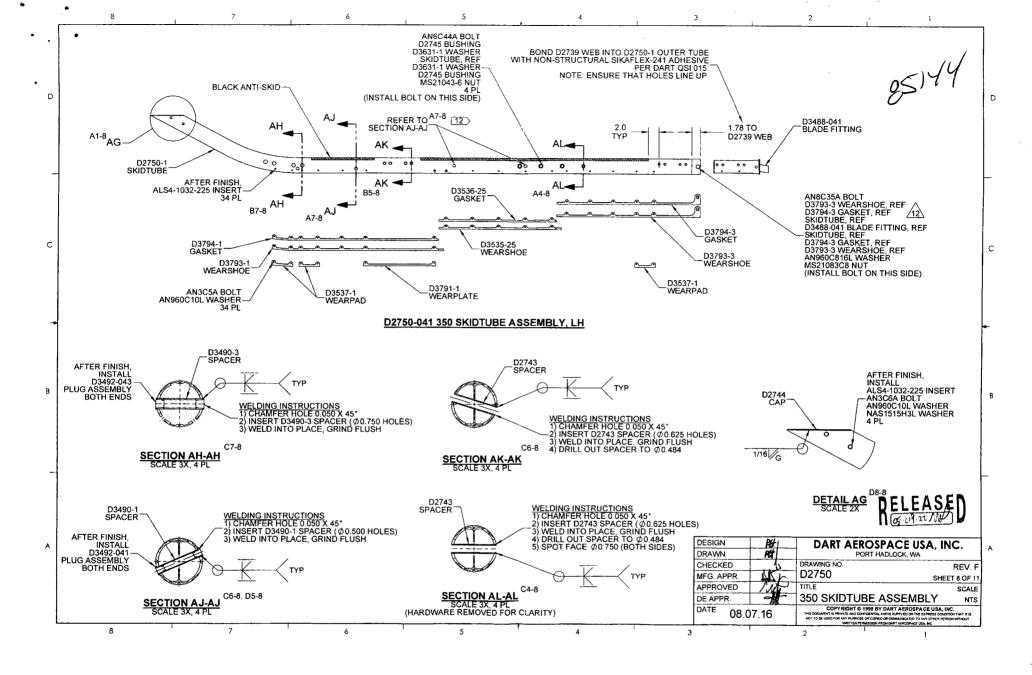
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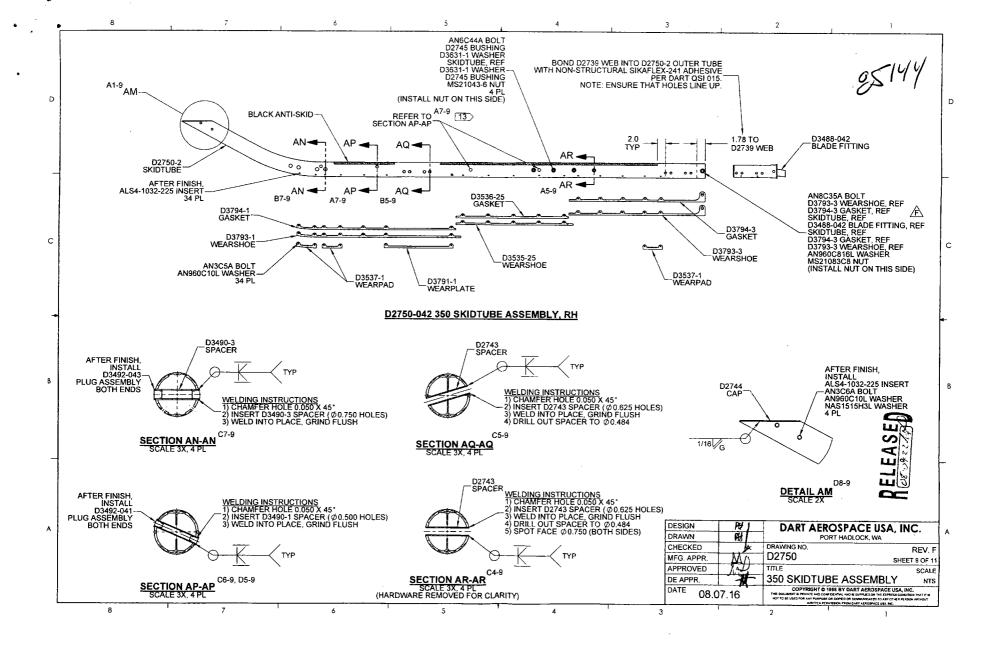
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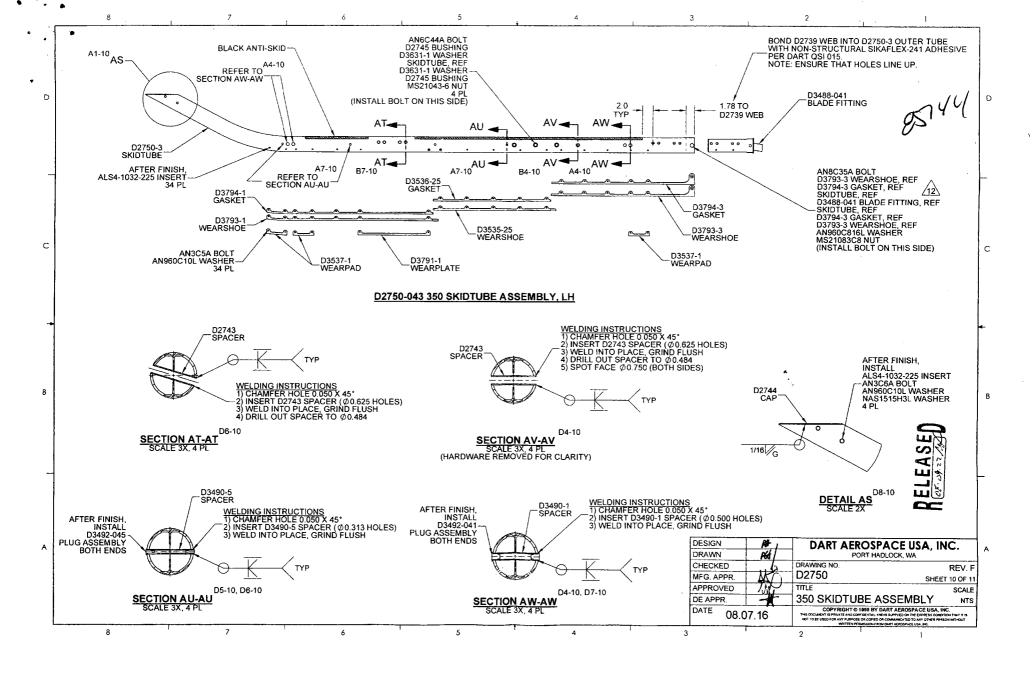
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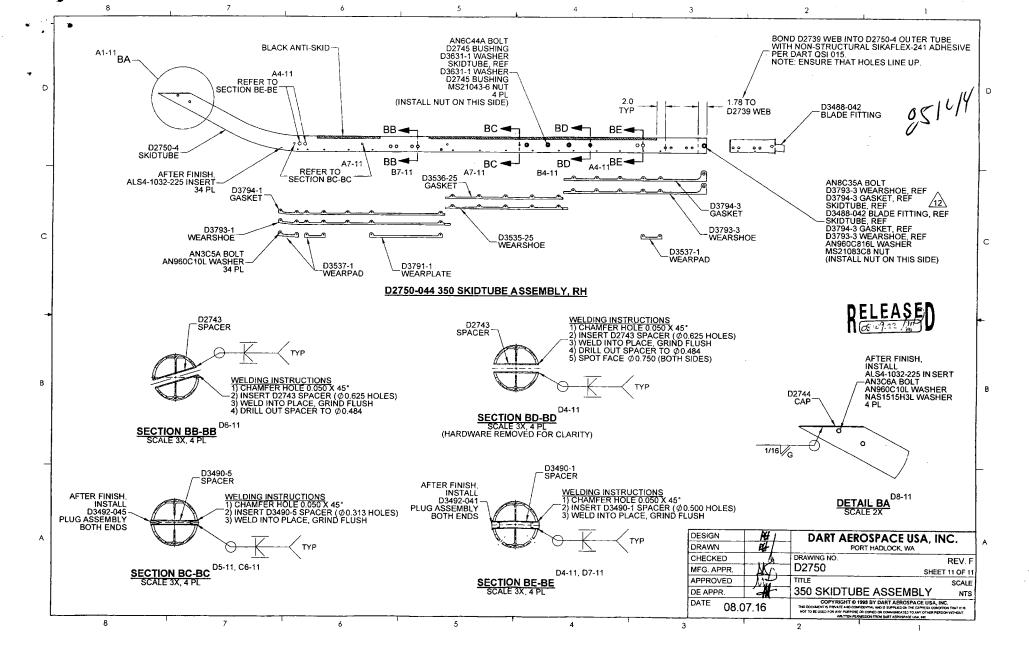


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NO. 294

AWS D17.1.2001 QUALIFICATION TEST RECORD

A L. KII LL
Name: Barday Elliott
Job number: <u> </u>
Part number: <u>4350-636-012</u>
Description: Skidfube
Welding Process: Tig[Mig[]
Base materiel: <u>Allum</u>
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[c] fail[] pass[c] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Bund Annal Welder Backey Elliott	Date of Test Coupon 12-05-09
The above named individual is qualif	fied in accordance with AWS D17.1.2001 to weld